

## CLAIMS

What is claimed is:

1. An alkylphenol ethoxylate-free polymer binder, said polymer binder formed by  
5 emulsion polymerization and having a peel value of 35 % to 200 % of a standard  
alkylphenol ethoxylate-based polymer binder control and a cure profile in which 55 %  
cure is achieved within 30 seconds of being exposed to a temperature required for cure,  
said polymer binder having properties that render it effective as a binder in a crepe  
process.

2. The polymer binder of claim 1 wherein said crepe process is a double recrepe  
process.

3. The polymer binder of claim 2 wherein the peel value is 50 to 125 % of control  
15 binder.

4. An alkylphenol ethoxylate-free polymer binder, said polymer binder formed by  
emulsion polymerization and having a peel value of 35 % to 200 % of a standard  
alkylphenol ethoxylate-based polymer binder control and a cure profile in which 55 %  
20 cure is achieved within 30 seconds of being exposed to a temperature required for cure,  
said polymer binder having properties that render it effective as a binder in a double  
recrepe process.